

303 100  
Work Order ID 77008

\*77008\*

Page 1

Thursday, November 24, 2011 3:20:20 PM

Item ID: D4171-1

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Bushing

Start Date: 11/24/2011 Start Qty: 12.00

\*12\*

Cust Item ID:

Required Date: 12/5/2011 Req'd Qty: 12.00

\*12\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4171

A

100

0.00

\*100\*

DOOSAN LATHE

Doosan

Memo

0.00

Doosan Lathe

1-Turn as per Dwg & Folio FA963  
2-Deburr

1012120

13

110

0.00

\*110\*

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

1112120

13

140

0.00

\*140\*

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

1112120

13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 77008

**\*77008\***

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Thursday, November 24, 2011 3:20:20 PM

Item ID: D4171-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Bushing  
 Start Date: 11/24/2011 Start Qty: 12.00 **\*12\*** Cust Item ID:  
 Required Date: 12/5/2011 Req'd Qty: 12.00 **\*12\*** Customer:

## Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***  
 Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Identify as per dwg & Stock Location: <u>135</u>	0.00							
<b>*200*</b>									
Packaging	Memo	0.00							
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00							
<b>*210*</b>									
QC	Memo	0.00							
Quality Control									

11/18/21 130

11/12/22 130

MF 11-12-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Thursday, November 24, 2011 3:20:25 PM

Page 1

Work Order ID: 77008

**\*77008\***

Parent Item: D4171-1

**\*D4171-1\***

Parent Item Name: Bushing

Start Date: 11/24/2011

Required Date: 12/5/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A NEW ISSUE 10-09-22 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R1.000		Purchased				100	f	13.9640	0.08	1.010526			
<b>*M303R1 000*</b>									<b>**</b>				
303 Round Bar 1.00													

Location

Loc Qty

Loc Code

MAT028

13.964

116700

1.107

117550

1.2

117598

9.04

118008

2.617

**SD 11/22/20**

**7.124**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

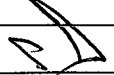
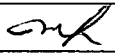
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	77005
<b>Description: Bushing</b>		<b>Part Number:</b>	D4171-1
<b>Inspection Dwg: D4171 Rev: A</b>		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.750	+/-0.010	.751	/			
0.540	+/-0.010	.541	/			
0.210	+/-0.010	.210	/			
0.150	+/-0.010	.155	/			
Ø0.305	+0.000/-0.002	Ø.303	/			
R0.010	+/-0.010	R.015	/			
0.060	+/-0.010	.055	/			
0.395	+0.015/-0.005	.397	/			
0.563	+0.002/-0.015	.554	/			
Ø0.88	+/-0.030	Ø.875	/			
Ø0.191	+0.005/-0.001	Ø.155	/			
R0.063	+/-0.010	R.063	/			
R0.060	+/-0.010	R.060	/			
45°	+/-0.5°	45°	/			
0.023	+0.030/-0.010	.035	/			
0.030 x 20°	+/-0.010 x 0.5°	0.03028	/			

<b>Measured by:</b>		<b>Audited by:</b>		<b>Preliminary Approval:</b>	
<b>Date:</b>	11/12/20	<b>Date:</b>	11/12/20	<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A	10.10.25	New Issue	KJ 	

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

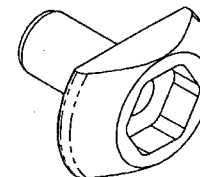
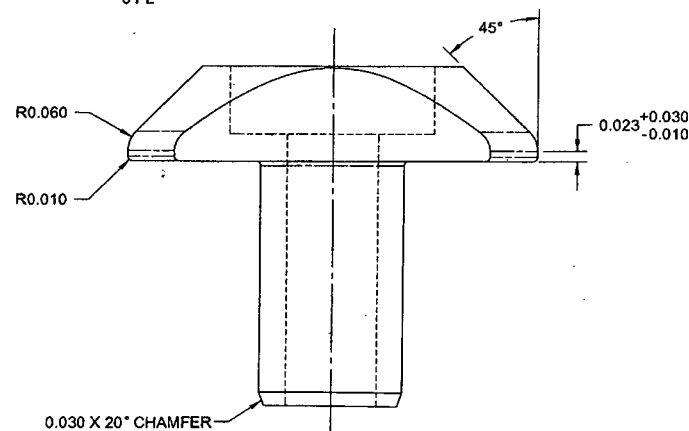
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





SHOP COPY  
RETURN TO  
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UNCONTROLLED COPY  
SUBJECT TO ASSIGNMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 77008

RELEASED  
2010-09-15  
MM

- 1) MATERIAL: AISI 303 STAINLESS STEEL ROUND BAR PER ASTM A582  
REF DART SPEC M303R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs
- 8) HEXAGONHOLE MUST ALLOW INSERTION OF AN3 BOLT.

A	NEW ISSUE		CP	10.08.26
REV.		DESCRIPTION	BY	DATE
DESIGN	<i>GP</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA  DRAWING NO. <b>D4171</b>  TITLE <b>BUSHING</b>		
DRAWN				
CHECKED	<i>h</i>			REV.
MFG. APPR.	<i>SW</i>			SHEET 1 OF
APPROVED	<i>SW</i>			SCAL
DE APPR.	<i>SW</i>			NT
DATE	10.08.26	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED BY ANY OTHER PERSON OR ENTITY		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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